

Work Order ID 140266

140266

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Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
 Revision ID:
 Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp. Stop *NS2*
 Start Date: 12/18/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/15/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: SH 20151218 Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	E								

100 Document Control 9-89 0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

record fwd angle:

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

89.60 15-12-22

DAS
28
9-89

MAR 15 2016

B140266 RH

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Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

Skidtubes

Memo

0.02

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

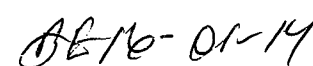
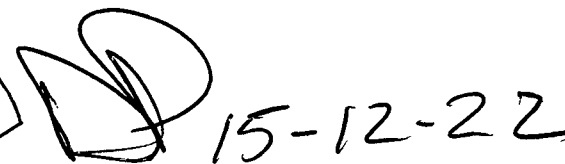
Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.

6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

7- Open up holes of Detail J to 0.297" (total of 2 holes per side)

8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004



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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/18/2015 **Start Qty:** 1.00 ***1***

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Required Date: 1/15/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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A/R Aluminum Rod batch: m132917

9- Grind welds flush as per Dwg D2750

120

QC10- Inspect visual per QSI004- ground welds	0.00
---	------

120

QC

Quality Control

Memo

0.00

DAS
38
9-89

JAN 18 2016

130

QC5- Inspect part completeness to step on W/O	0.00
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130

QC

Quality Control

Memo

0.00

DAS
38
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Stop *NS2*

Start Date: 12/18/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/15/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

Memo

0.01

HandFinish

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

0.00

150

Memo

0.00

QC

Quality Control

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Start Date: 12/18/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/15/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.02

1- Open up holes of Detail L using hole saw and ground handling to 0.625"
(total of 8 holes per side) as per dwg D2750.

2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float holes using uni-bit to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750
(welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per OSI 015, let cure for 12hrs.

A/R Sikaflex-291

batch: 133427exp. date: 16-2-12

****ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)****

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & OSI004
(welding instructions on sheet 9)

A/R Aluminum Rod

batch: MB3816

9- At section AP-AP drill out x-bolt spacer to 0.404"

10- Grind welds flush as per Dwg D2750

16-1-24

16-1-28 JL

7 846-02-03
16-2-4 JL

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Stop ***NS2***Start Date: 12/18/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11- Spot face ground handling holes section (total of 4 places per side) as per
dwg D275012- Deburr holes, ensure tube is free of all scratches before sending to
paint.

170

QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo 0.00

Quality Control

DAS
38
9-89

FEB 05 2016

180

QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo 0.00

Quality Control

VERIFY C'BOARD IS GOOD

DAS
38
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FEB 05 2016

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
100									
HandFinish	Memo	0.01							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							DAS 41 9-89
200									
SprayPaint	Memo	0.01							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>132919</u>								16-2-16
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>133885</u>								
210	QC14- Inspect Spray Paint	0.00							
210									DAS 15 9-89
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.02							
Hand Finishing	Memo								
	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>M1133862</u>								
	EXP DATE: <u>16/13</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>M1133145</u> RTU 598 M133436 16/05								
	5-Coat all exposed fasteners with "LPS Procyon"								
	batch: <u>M1122900</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	0.00							
Quality Control	Memo								

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Item ID: D350-636-012

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N900040100Setup Start ***NS1***

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Start Date: 12/18/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

250

Packaging	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Packaging

DAS
6
9-89

MAR 15 2016

260	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

260

QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

DAS
28
9-89

MAR 15 2016

270		0.00							
-----	--	------	--	--	--	--	--	--	--

270

Packaging		0.00							
-----------	--	------	--	--	--	--	--	--	--

Packaging

Memo

Package as per PPP D350-636-012
Location : FG072DAS
27
9-89

MAR 16 2016

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Item ID: D350-636-012

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N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MCS MAR 16 2016

Picklist Print

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07-13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT-RH		Manufactured	No			110	Each	7.0000	1	1			
D2600-3-BENT-RH									**				
Extrusion Bent RH													
				<u>Location</u>				<u>Loc Qty</u>					
				LG002				7					
				137808				2					
				139100				5					
D2744		Manufactured	No			110	Each	1.0000	1	1			
D2744									**				
Cap													
				<u>Location</u>				<u>Loc Qty</u>					
				LG001				1					
				136178				1					
D2739		Manufactured	No			160	Each	3.0000	1	1			
D2739									**				
350 I Beam													
				<u>Location</u>				<u>Loc Qty</u>					
				LG002				3					
				139095				3					

DD 15-12-22

①

BE 16-01-14
8137684

16-1-28

140830

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

107.0000

8

8

D2743

Crossbolt Spacer

**

BE16-02-03

Location

Loc Qty

Loc Code

LG

34

138392

34

LG001

73

137271

8

139032

65

D3490-3

Manufactured No

160

Each

42.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE16-02-03
B140801 14

Location

Loc Qty

Loc Code

LG001

42

137807

6

139099

16

139710

20

D3490-1

Manufactured No

160

Each

22.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE16-02-03
B140802 14

Location

Loc Qty

Loc Code

LG

14

133205

14

LG001

8

134019

8

Picklist Print

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Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230

Each

90.0000

8

8

D3631-1

Washer

ll 16/02/23

Location

Loc Qty

Loc Code

FP001

90

B 140533

X3

135951

3

139226

87

X3

D3791-1

Manufactured No

230

Each

24.0000

1

1

D3791-1

Wearpad

ll 16/02/23

Location

Loc Qty

Loc Code

FP002

24

128234

1

139736

23

X1

D3793-3

Manufactured No

230

Each

23.0000

1

1

D3793-3

Wearplate Aft

ll 16/02/23

Location

Loc Qty

Loc Code

FP002

23

130534

1

139733

22

X1

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Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

61.0000

4

4

MS21043-6******

NUT

ll 16/02/23

LocationLoc QtyLoc Code

FG

20

103693

20

M1133992

x d

FP001

41

131618

2

m130325

2

m133483

4

m133733

33

D3794-1

Manufactured

No

230

Each

26.0000

1

1

D3794-1******

Gasket Fwd

ll 16/02/23

LocationLoc QtyLoc Code

FP001

26

130509

2

139039

24

x l

NAS1611-010

Purchased

No

230

Each

235.0000

8

8

NAS1611-010******

O-RING

ll 16/02/23

LocationLoc QtyLoc Code

FP001

235

m130770

175

m131618

60

x g

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Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

38.0000

1

1

D2741

Replacement Blade

**

14/00/

DAS
6
9-89
27
9-89

MAR 15 2016

DAS
28
9-89LocationLoc QtyLoc Code

FG	10	
131616	10	
ST538	28	
132981	16	
135909	12	

NAS1515H3L

Purchased No

230

Each

179.0000

4

4

***NAS1515H3I ***

Washer

**

lll 16/02/23

LocationLoc QtyLoc Code

FG	40	
102472	40	
FP001	55	
m127831	55	
ST266	84	
m127831	32	
m130726	52	

NAS1611-013

Purchased No

230

Each

262.0000

8

8

NAS1611-013

O-Ring

**

lll 16/02/23

LocationLoc QtyLoc Code

FP001	262	
m130758	62	
m133812	200	

x8

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Shop Packet Print

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Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

153.0000

4

4

AN3C6A******

Bolt

ll 140266

LocationLoc QtyLoc Code

CA

31

M133996

x4

m128704

31

FG

10

122416

10

FP001

9

m133363

9

ST338a

36

m128769

30

m133077

6

ST349

67

m132767

4

m133694

63

NAS1149C0832R

Purchased

No

230

Each

72.0000

1

1

NAS1149C0832R******

Washer

ll 140266

LocationLoc QtyLoc Code

FP001

10

m125807

10

x1

ST271

62

m125807

62

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Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

24.0000

1

1

D3536-25 ✕

Gasket Center

all 16/02/26

Location

Loc Qty

Loc Code

FG

6

3141380

87053

2

xi

95328

4

FP001

18

105965

1

130823

1

132316

1

139433

1

139735

14

D3794-3

Manufactured No

230

Each

13.0000

1

1

D3794-3

Gasket Aft

all 16/02/23

Location

Loc Qty

Loc Code

FP001

13

314134

125917

1

xi

127383

11

92658

1

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D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,207.000

34

34

AN3C5A

Bolt

**

16/02/23

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

478

M133234

54

M133769

424

OVER002

600

M133686

600

ST338a

124

M125388

35

m127290

3

M131803

42

M132640

44

X34

D3537-1

Manufactured

No

230

Each

100.0000

3

3

D3537-1

Wearpad

**

16/02/23

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

82

107384

5

125911

1

128225

1

136314

7

136712

21

136713

47

B136714

X3

Picklist Print

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Page 9

Work Order ID: 140266

140266

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

3.0000

1

1

D3535-25

Wearplate Center

**

ll 16/02/27

Location

Loc Qty

Loc Code

FG

3

B139732

X1

128224

1

95077

2

D3492-3

Manufactured No

230

Each

136.0000

8

8

D3492-3

Plug

**

ll 16/02/27

Location

Loc Qty

Loc Code

FP001

136

133470

3

138358

45

139006

8

139597

80

X8

NAS1149C0332R

Purchased

No

230

Each

3,056.000

38

38

NAS1149C0332R

WASHER

**

ll 16/02/27

Location

Loc Qty

Loc Code

FP001

1605

M1134073

X39

m132262

4

m132930

1004

m133284

597

GA

343

m133284

343

ST266

1108

m133284

1108

Picklist Print

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Page 10

Work Order ID: 140266

140266

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

14.0000

1

1

D3488-042

Blade Fitting RH

ll 16/02/23

Location

Loc Qty

Loc Code

FP001

14

129602

3

138866

11

X1

ALS4-1032-225

AELS8-1032-225 Purchased

No

230

Each

730.0000

38

38

AI S4-1032-225

Rivnut

ll 16/02/23

ALS7-1032-225

Location

Loc Qty

Loc Code

FG

120

M127028

120

11133799

X38

FP001

610

M133772

610

D3492-1

Manufactured No

230

Each

71.0000

8

8

D3492-1

Plug

ll 16/02/23

Location

Loc Qty

Loc Code

FP001

71

138411

5

139053

6

139632

60

B141659

X2

D3793-1

Manufactured No

230

Each

25.0000

1

1

D3793-1

Wearplate Fwd

ll 16/02/23

Location

Loc Qty

Loc Code

FP002

25

130508

1

139734

24

X1

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Shop Packet Print

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Picklist Print

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Page 11

Work Order ID: 140266

140266

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

70.0000

1

1

AN8C35A

Bolt

**

ll 16/02/23

Location

Loc Qty

Loc Code

FG

5

121275

5

FP001

35

m131947

1

m132381

15

m132522

15

m132674

4

over005

30

m133332

15

m133336

15

MS21083C8

Purchased

No

230

Each

43.0000

1

1

MS21083C8

Nut

**

ll 16/02/23

Location

Loc Qty

Loc Code

ST297

43

m132067

2

m133016

2

m133577

25

m133694

14

D2745

Manufactured

No

230

Each

85.0000

8

8

D2745

Bushing

**

ll 16/02/23

Location

Loc Qty

Loc Code

FP001

85

129584

7

136214

2

137731

1

138363

75

B141061

x 5

V3

December 18, 2015 2:49:21 PM

Shop Packet Print

Page 11

Picklist Print

December 18, 2015 2:49:21 PM

Page 12

Work Order ID: 140266

140266

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

517.0000

4

4

AN6C44A

Bolt

**

12/16/2015

Location

Loc Qty

Loc Code

FP001

91

131649

54

m131367

1

m132381

36

over009

361

m130863

13

m131151

50

m132522

52

m132556

246

ST332

11

m130863

11

ST333

54

m130863

4

m131946

50

D3532-1

Manufactured

No

250

Each

6.0000

2

2

D3532-1

Spacer

**

140224

Location

Loc Qty

Loc Code

ST041

6

139065

6

DAS
28
9-89

DAS
28
9-89

MAR 04 2016

Picklist Print

December 18, 2015 2:49:21 PM

Page 13

Work Order ID: 140266

140266

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

43.0000

2

2

MS21083C8

Nut

**

133990X1

DAS

6

9-89

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST297

43

m132067

2

m133016

2

m133577

25

m133694

14

NAS1149D0863J

Purchased

No

250

Each

556.0000

2

2

NAS1149D0863J

Washer

**

DAS

6

9-89

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

47

125484

47

ST260a

415

125268

315

125635

100

ST269

94

125268

94

D3493-1

Manufactured

No

250

Each

40.0000

2

2

D3493-1

Washer

**

DAS

27

9-89

DAS

6

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST039

30

137724

7

139595

23

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

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Shop Packet Print

Page 13

MAR 04 2016

Picklist Print

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Page 14

Work Order ID: 140266

140266

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

44.0000

2

2

AN8C21A

Bolt

Location

Loc Qty

Loc Code

FG

4

123966

2

m132169

2

ST332

40

m131100

1

m132169

2

m132381

1

m132522

4

m132674

4

m133322

28

DAS
28
9-89

DAS
6
9-89
MAR 04 2016

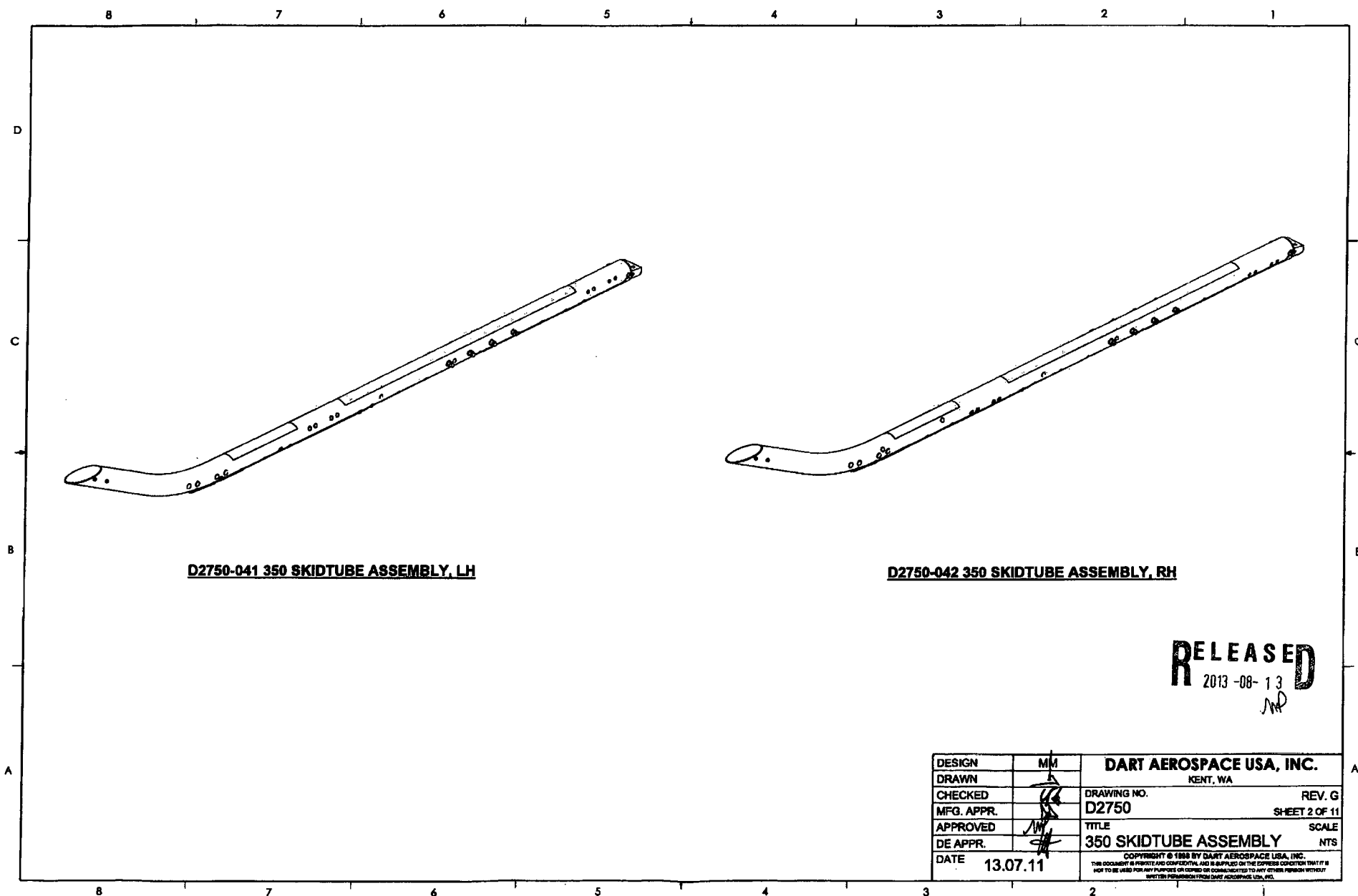
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X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL "F" SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
 FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

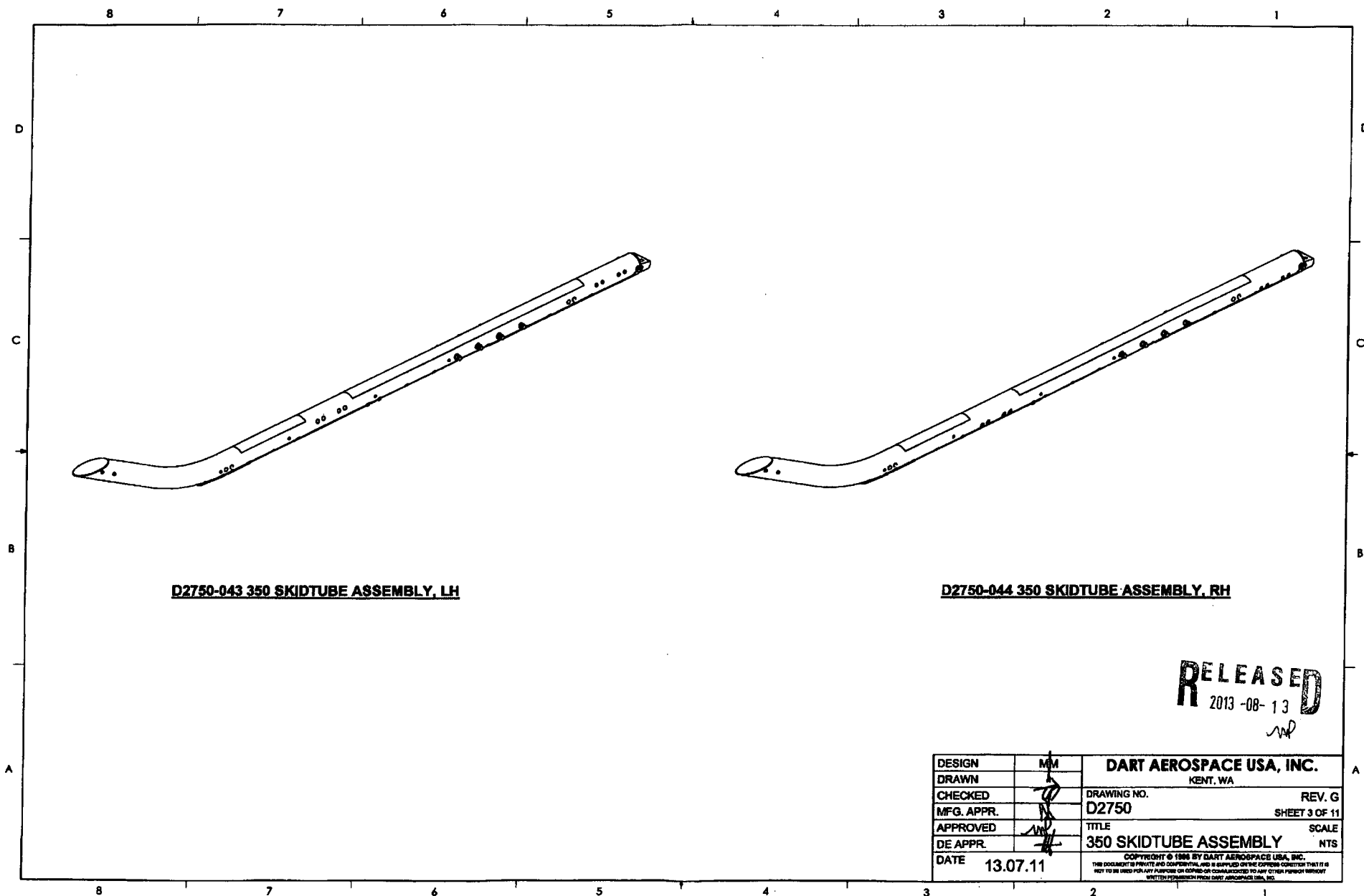
RELEASED
2013-08-13
20151218 140266ND

G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-278 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-5293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUBJECT TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



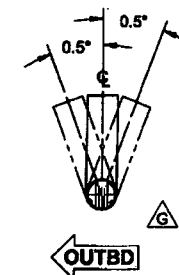
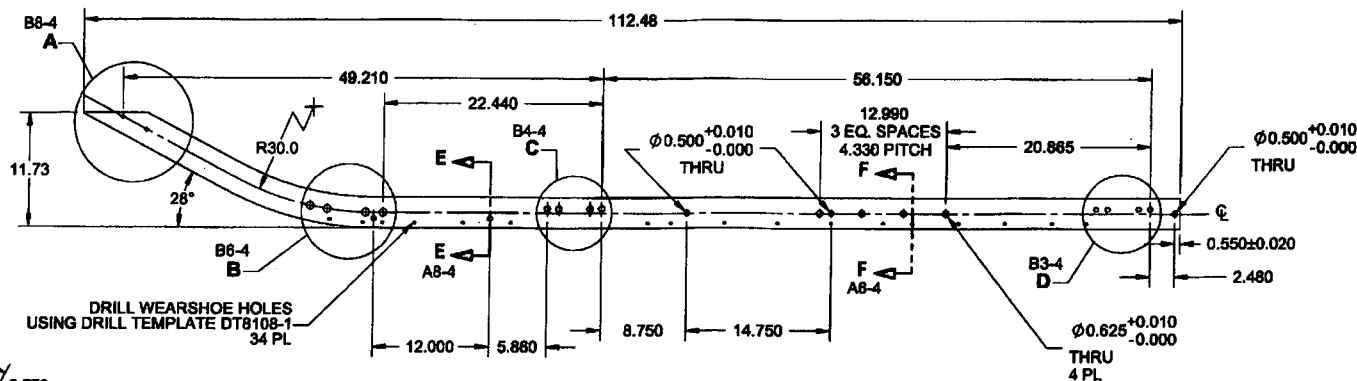
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2013-08-13
ND

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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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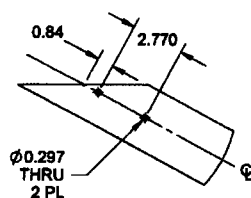
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2013-08-13
wp

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DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1996 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

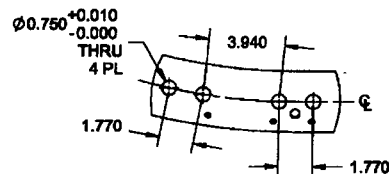


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

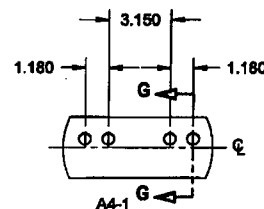
D2750-1 LH SKIDTUBE



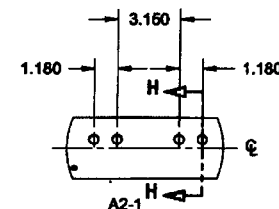
DETAIL A
SCALE 2X



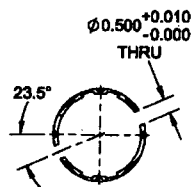
DETAIL B
SCALE 2X



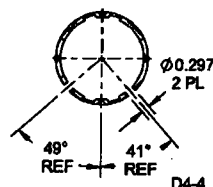
DETAIL C
SCALE 2X



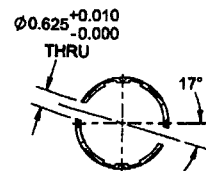
DETAIL D
SCALE 2X



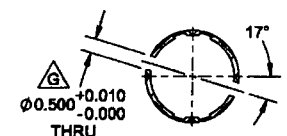
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

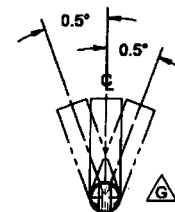
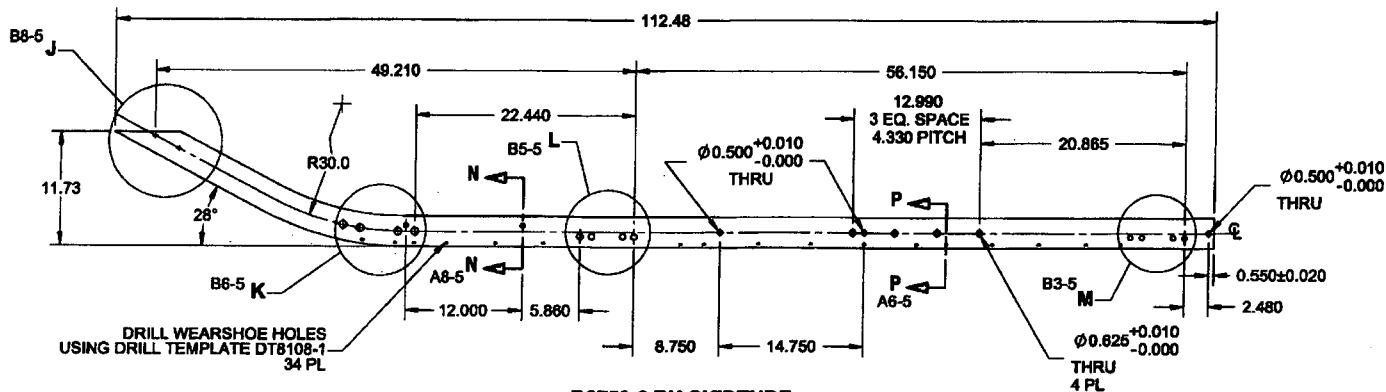


SECTION H-H
SCALE 3X, 4 PL

RELEASED
2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.
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CHECKED		
MFG. APPR.		DRAWING NO. D2750
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY
DE APPR.		SCALE NTS
DATE	13.07.11	

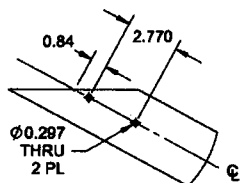
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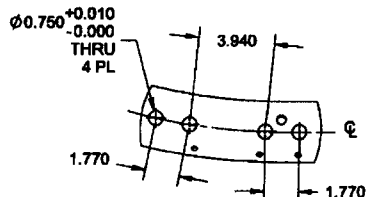
OUTBD

MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

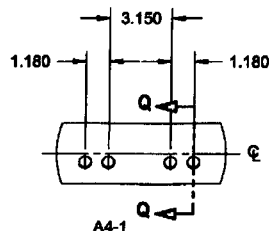
D2750-2 RH SKIDTUBE



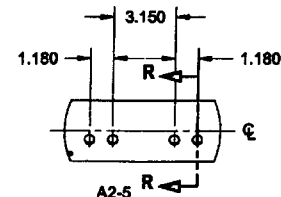
DETAIL J
SCALE 2X



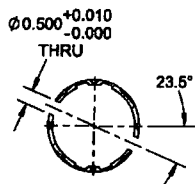
DETAIL K
SCALE 2X



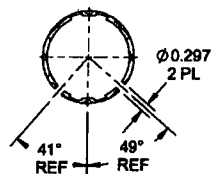
DETAIL L
SCALE 2X



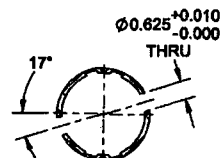
DETAIL M
SCALE 2X



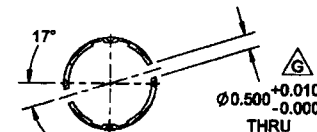
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

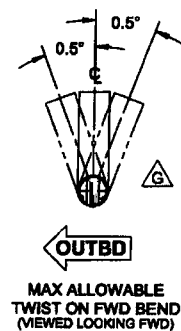
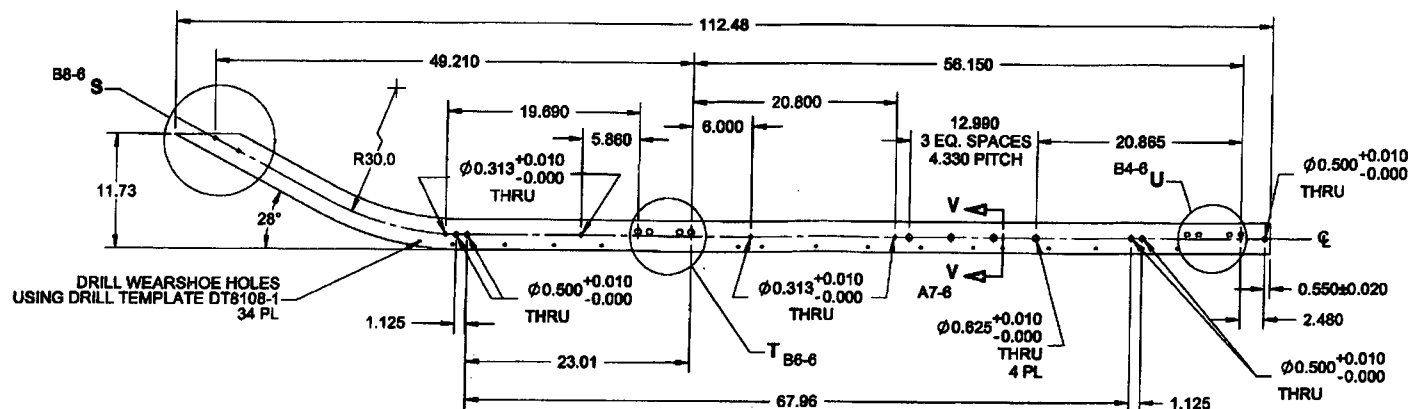


SECTION R-R
SCALE 3X, 4 PL

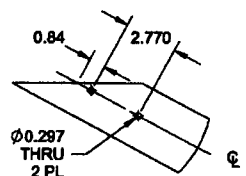
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DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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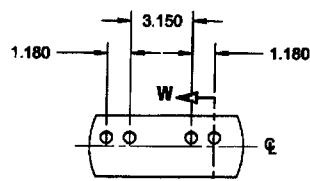
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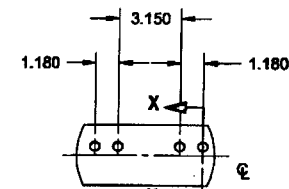
D2750-3 LH SKIDTUBE



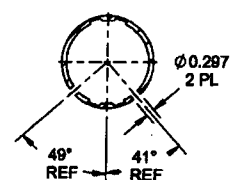
DETAIL S
D8-6
SCALE 2X



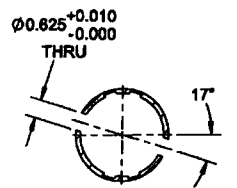
DETAIL T
C5-6
SCALE 2X



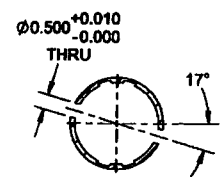
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B8-6
SCALE 3X, 4 PL

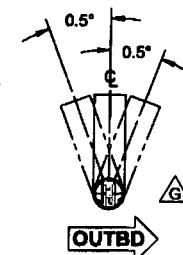
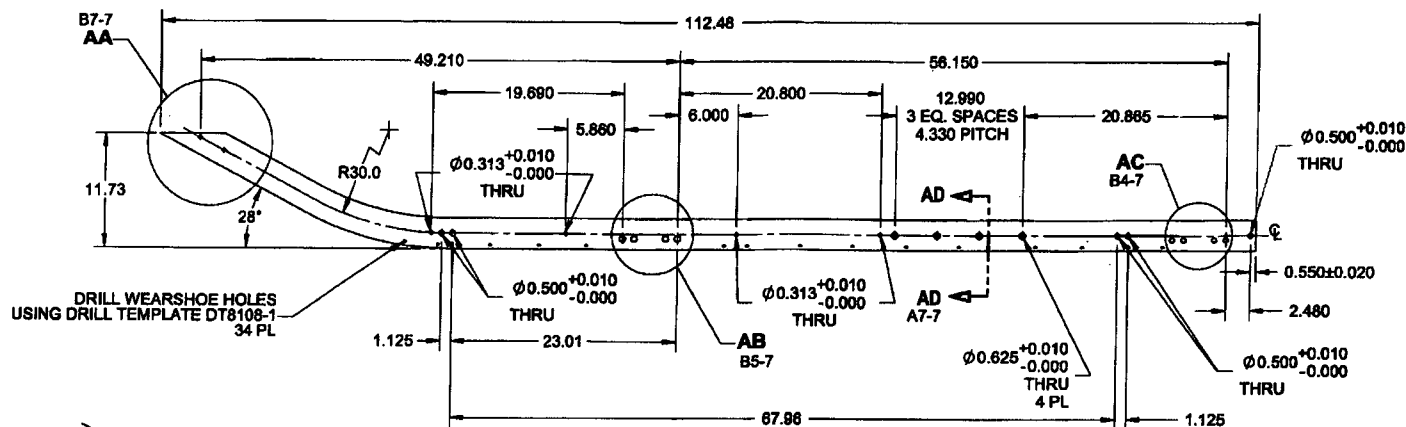


SECTION X-X
B4-6
SCALE 3X, 4 PL

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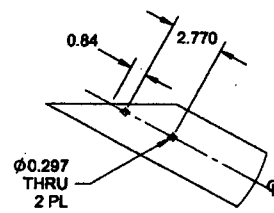
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8 7 6 5 4 3 2 1

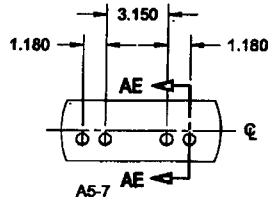


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

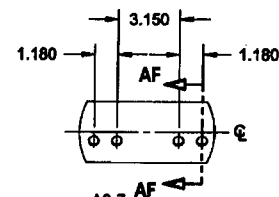
D2750-4 RH SKIDTUBE



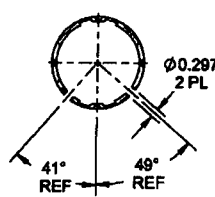
DETAIL AA
SCALE 2X



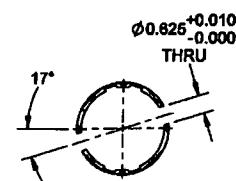
DETAIL AB
SCALE 2X



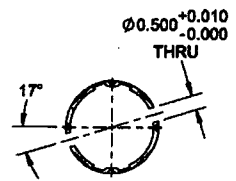
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



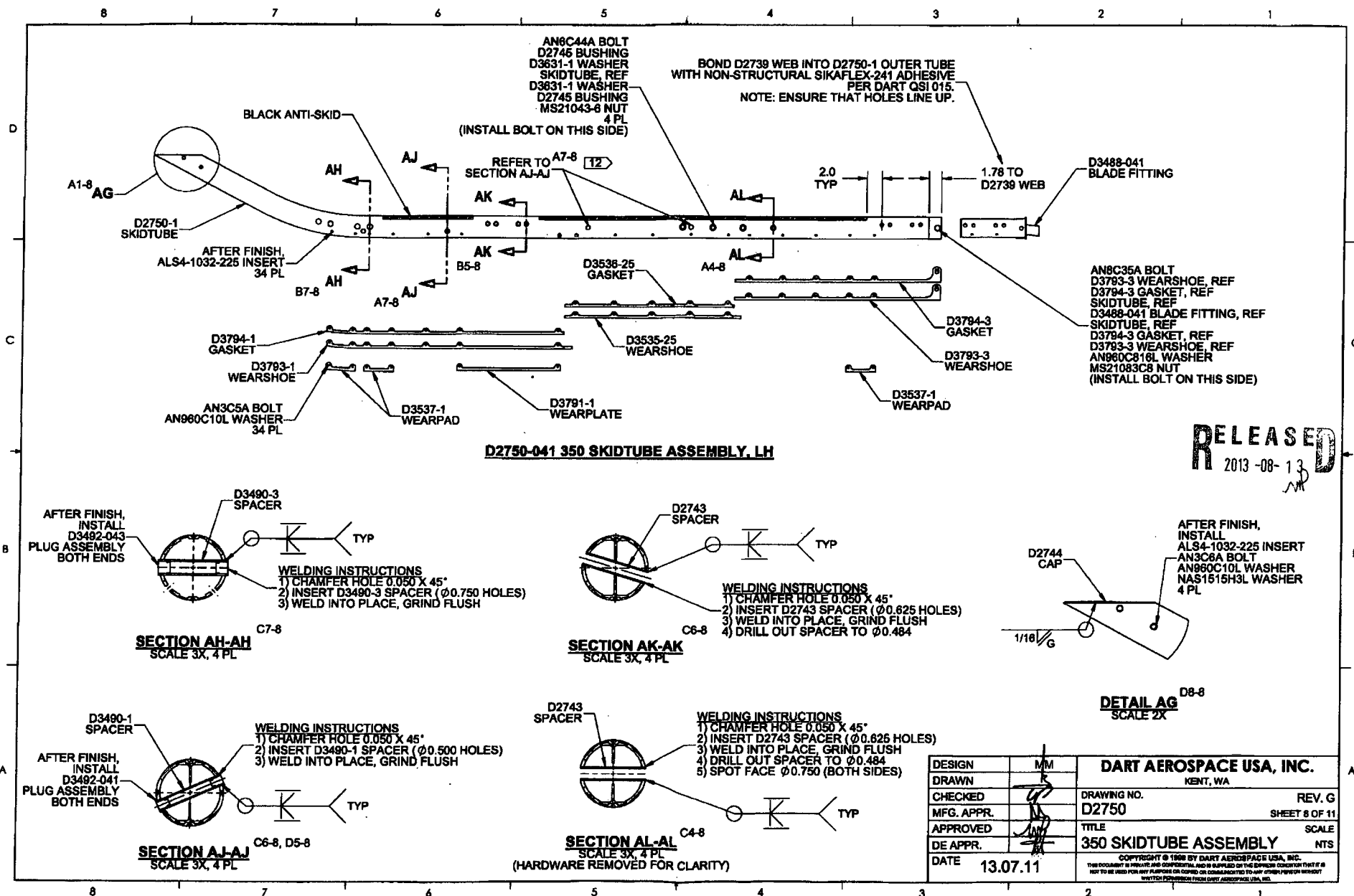
SECTION AE-AE
SCALE 3X, 4 PL

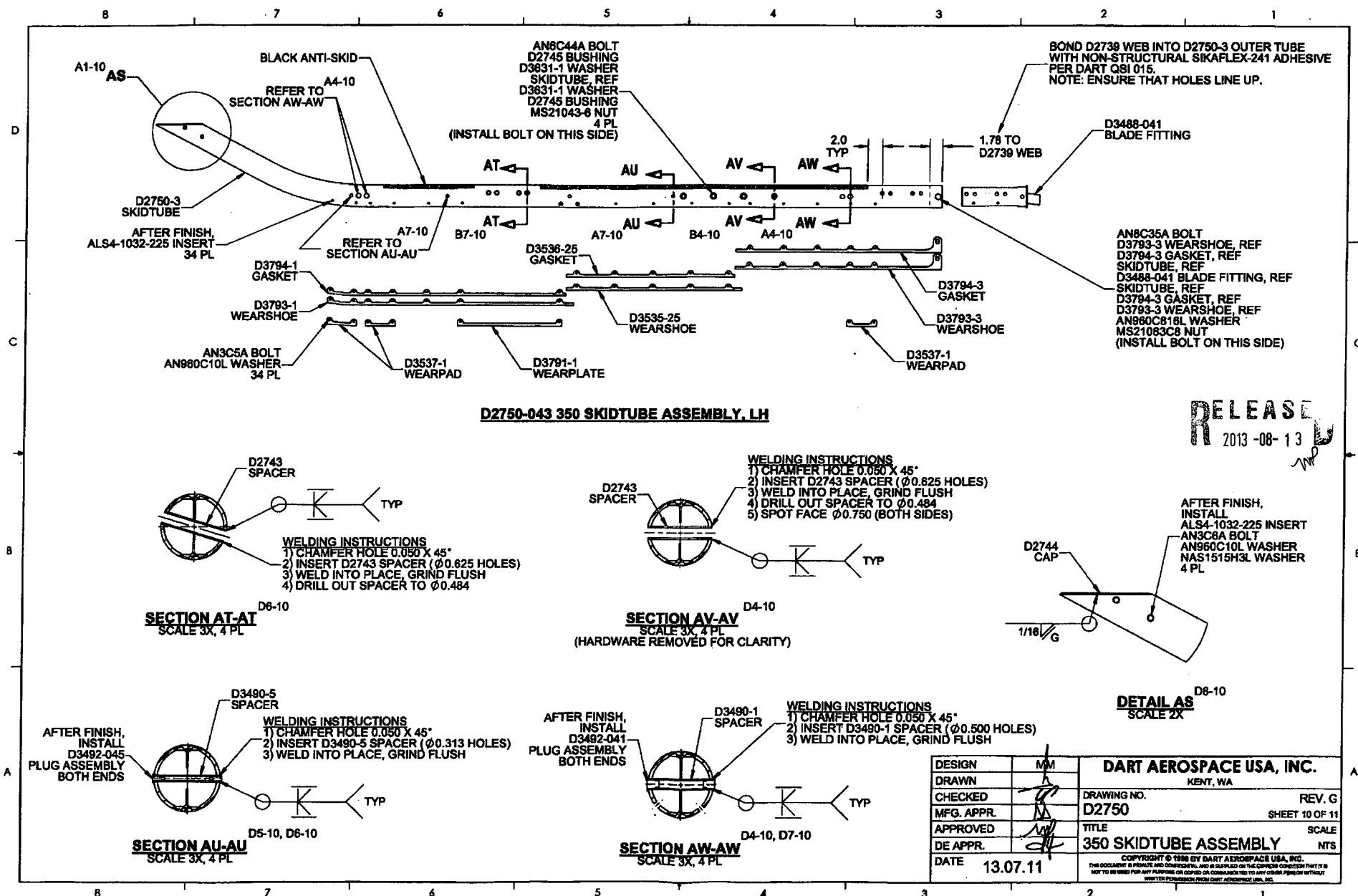


SECTION AF-AF
SCALE 3X, 4 PL

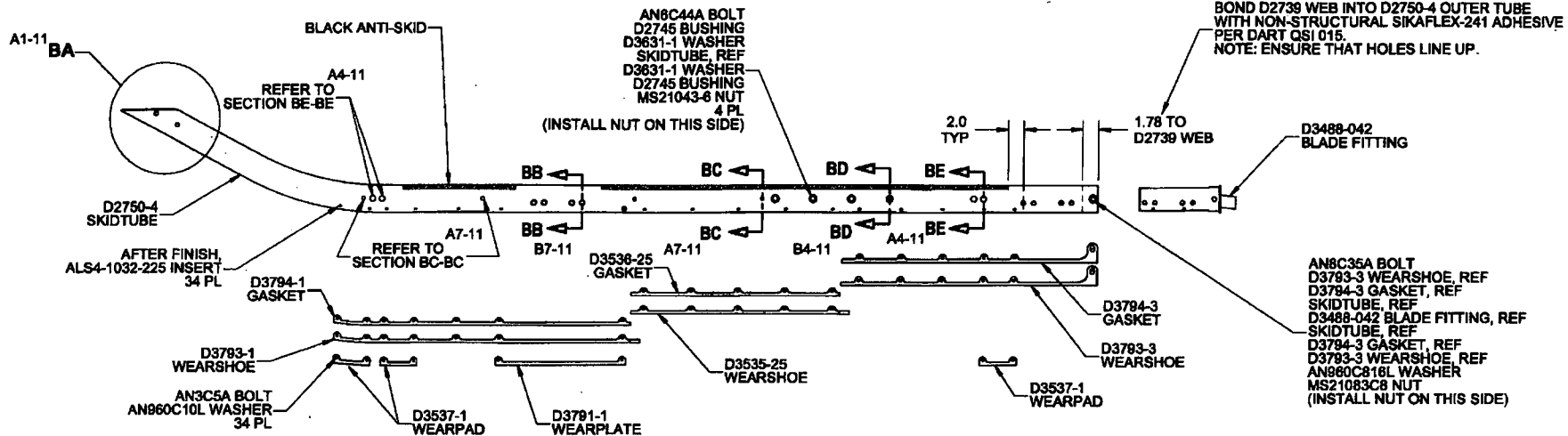
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DESIGN	MM	DART AEROSPACE USA, INC.	
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MFG. APPR.		D2750	SHEET 7 OF 11
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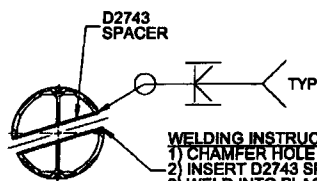




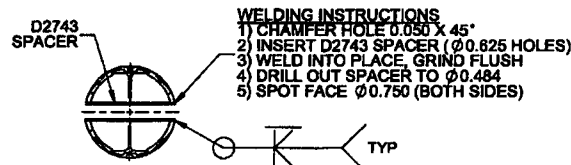
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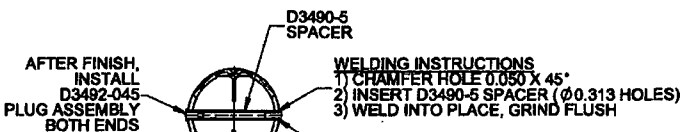
D2750-044 350 SKIDTUBE ASSEMBLY, RH



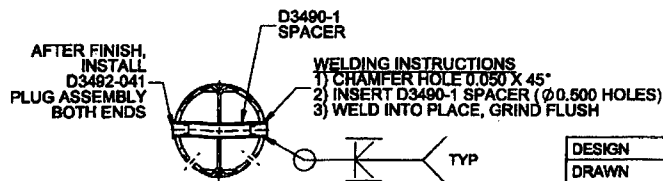
SECTION BB-BB
SCALE 3X, 4 PL



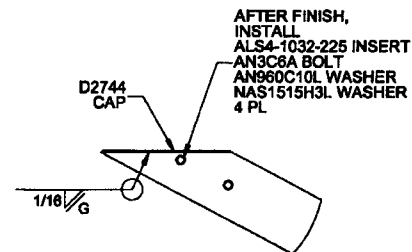
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

DESIGN	MM	DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 11 OF 11
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2013-08-13

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION
X								D3492-041	PLUG ASSEMBLY
	X							D3492-043	PLUG ASSEMBLY
		X						D3492-045	PLUG ASSEMBLY
			X					D3492-047	PLUG ASSEMBLY
				X				D3492-049	PLUG ASSEMBLY
					X			D3492-051	PLUG ASSEMBLY
						X		D3492-053	PLUG ASSEMBLY
							X	D3492-055	PLUG ASSEMBLY
1								D3492-1	PLUG
	1							D3492-3	PLUG
		1						D3492-5	PLUG
			1					D3492-7	PLUG
				1				D3492-9	PLUG
					1			D3492-11	PLUG
						1		D3492-13	PLUG
							1	D3492-15	PLUG
		1						NAS1611-005	O-RING
			1					NAS1611-007	O-RING
1								NAS1611-010	O-RING
						1		NAS1611-012	O-RING
	1							NAS1611-013	O-RING
					1		1	NAS1611-015	O-RING
				1				NAS1611-016	O-RING

NOTES:

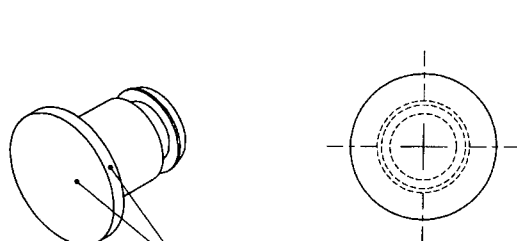
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047: UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	11	D3492	SHEET 1 OF 2
APPROVED	11	TITLE	SCALE
DE APPR.	11	PLUG	NTS
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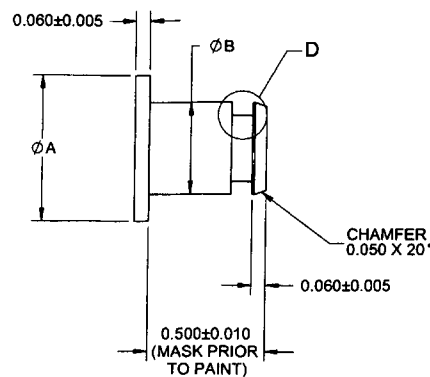
RELEASED
2013-11-13

20151218

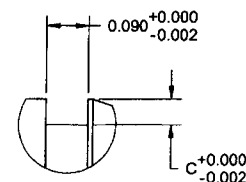
SH 170266



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750
D3492-15	0.850	0.640	0.050	M6061T6R0.875

△

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
2013-11-13

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO.	REV. E
MFG. APPR.	MS	D3492	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	PLUG	4:1
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Work Order ID 140266

140266

Page 1

December 18, 2015 2:49:16 PM

Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp. Stop *NS2*

Start Date: 12/18/2015 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: SH 20151218 Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr.								
D2750-042	G								
D3492	E								

100 Document Control 0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

record fwd angle:

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

MCS MAR 11 7 2016

15-12-22